

Work Order ID 80324

80324

Page 1

February-17-12 8:26:29 AM

Item ID: D3508-11 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Wearplate
 Start Date: 17/02/2012 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 02/03/2012 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/02/17 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3508	Rev C								

100 0.00
 100 FLOW WATER JET
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg D3508 Dwg Rev: C Prog Rev: C 2-
 Deburr if necessary

1312-2-28

(4)

110 0.00
 110 QC2- Inspect parts off machine FAI/FAIB
 QC Memo 0.00
 Quality Control

1312-2-29

120 0.00
 120 QC8- Inspect parts - second check
 QC Memo 0.00
 Quality Control

812/02/20

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	NC BRAKE	0.00							
130						(4)			
Brake NC	Memo	0.00							
Brake NC	1-Form on brake using DT8326 and DT8261 as per Dwg D3508			5 12/03/01					
140	QC5- Inspect part completeness to step on W/O	0.00							
140						(4)			
QC	Memo	0.00		8 12/03/01					
Quality Control									
150	Grey Sandtex(Ref:4.3.5.6) per QS1005 4.3	0.00							
150									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 7:50 OVEN TEMPERATURE: 3200F								
	FINISH TIME: 8:20								

W 11 8484

4X4 m-12/03/02

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 Reference:

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160						4x	6	12/21/02	
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: <u>1-P-1</u>	0.00							
170						4x	6	12/01/02	
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180						MLJ	12/03/02		
QC	Memo	0.00							
Quality Control									

12-03-2
6

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NOTE: Date & initial all entries

Picklist Print

Page 1

February-17-12 8:26:34 AM

Work Order ID: 80324

80324

Parent Item: D3508-11

D3508-11

Parent Item Name: Wearplate

Start Date: 17/02/2012

Required Date: 02/03/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07.06.12 EC
IPP Rev:B Rev C dwg 07-12-06 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	275.0165	0.5887	2.478737	6		

M304S20GA

304/316 .040 Sheet

**

8122-28

Location

Loc Qty

Loc Code

MAT020

275.0165

116623

0.2

117933

27.3442

118400

21.1723

118964

36.5

119346

29.8

120604

160

170604

(4)

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	80324
Description: Wearplate		Part Number:	D3508-11
Inspection Dwg: D3508 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.063	+/-0.010	2.070	2		V B02	
2.813	+/-0.010	2.813	2		V	
0.375	+/-0.010	.371	2		V	
5.625	+/-0.010	5.625	2		T B02	
22.500	+/-0.010	22.500	2		T	
26.50	+/-0.030	26.50	2		T	
Ø0.188	+0.005/-0.001	.192	2		V	
0.300	+/-0.010	.301	2		V	
0.300	+/-0.010	.303	2		V	
0.038	+/-0.010	.037	2		V	

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 12-2-28	Date: 12/02/28	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.07.24	New Issue	KJ/DD	

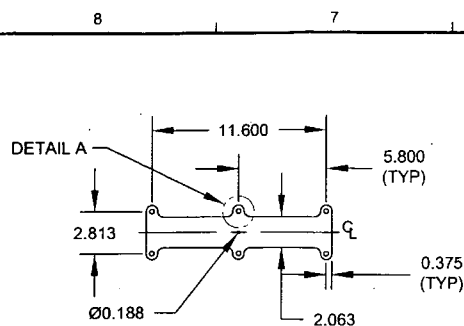
W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

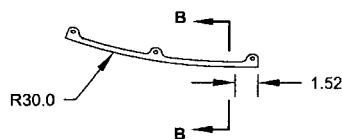
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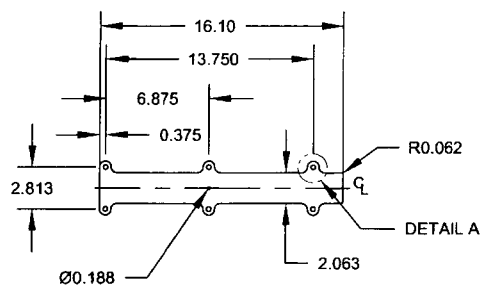
NOTE: Date & initial all entries



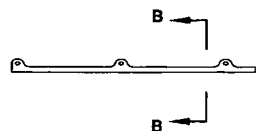
D3508-1 FLAT PATTERN



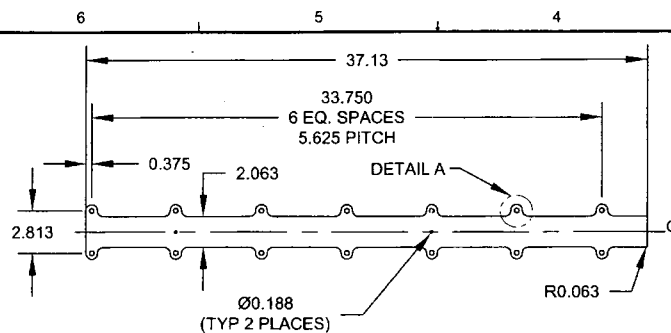
D3508-1 BENDING DETAIL
(MAKE FROM D3508-1F)



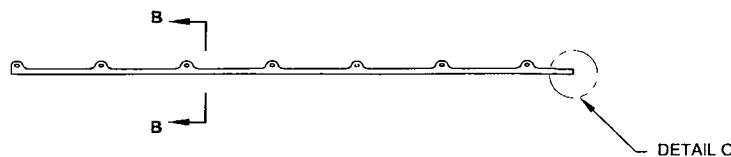
D3508-7F FLAT PATTERN



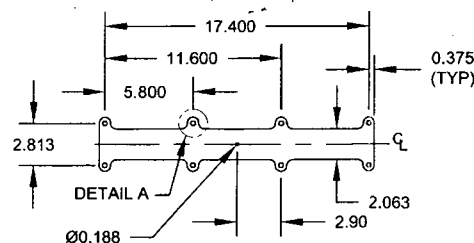
D3508-7F BENDING DETAIL
(MAKE FROM D3508-7F)



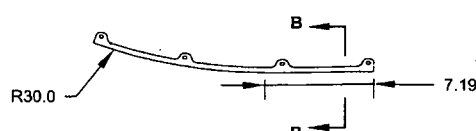
D3508-3 FLAT PATTERN



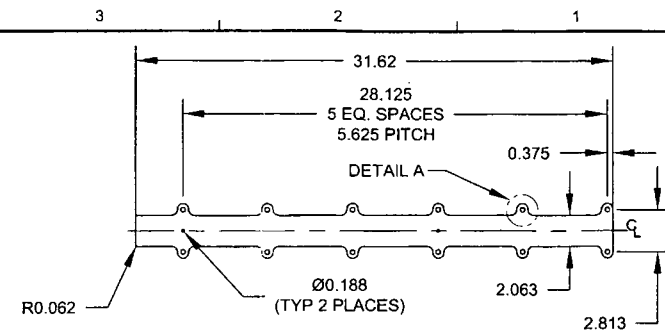
D3508-3 BENDING DETAIL
(MAKE FROM D3508-3F)



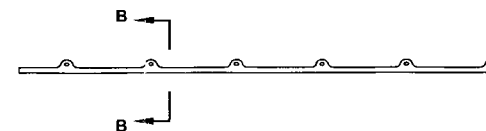
D3508-9F FLAT PATTERN



D3508-9F BENDING DETAIL
(MAKE FROM D3508-9F)



D3508-5 FLAT PATTERN



D3508-5 BENDING DETAIL
(MAKE FROM D3508-5F)

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF. DART MATERIAL SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.015
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: D3508-1 - 0.47 lbs, D3508-3 - 0.95 lbs, D3508-5 - 0.77 lbs,
D3508-7 - 0.39 lbs, D3508-9 - 0.45 lbs, D3508-11 - 0.64 lbs
D3508-13 - 0.25 lbs

RELEASED
07-11-16

M.L.J.
12/02/17
80324

C	ADD -9/-11/-13 MOVE TAB OUTBOARD (2.813 WAS 2.733) CHANGE DRAWING FORMAT	PH	07.04.20
B	CHANGE STAINLESS STEEL, WIDEN	PH	06.10.27
A	NEW ISSUE	PH	08.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE USA, INC	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3508	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	1:8
DATE	07.04.20	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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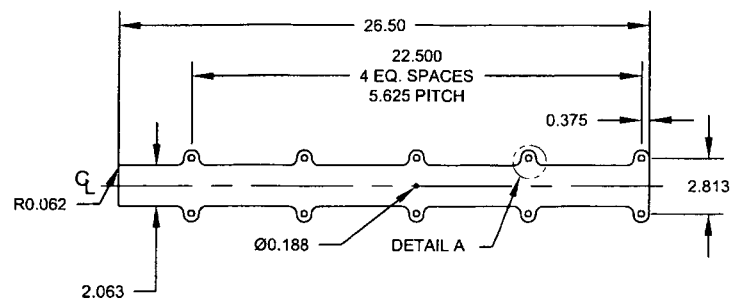
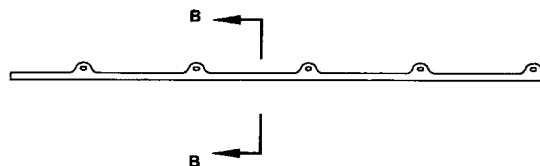
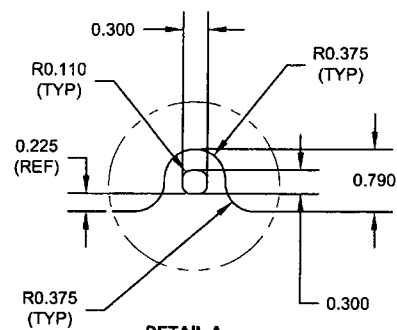
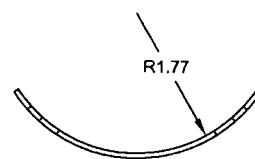
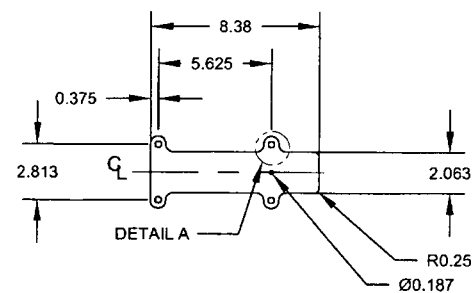
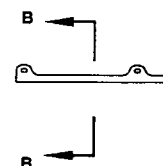
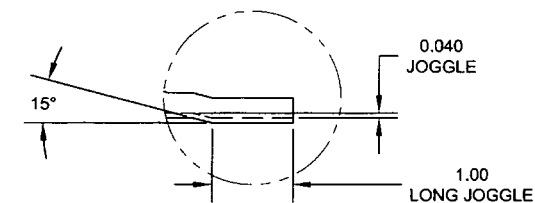
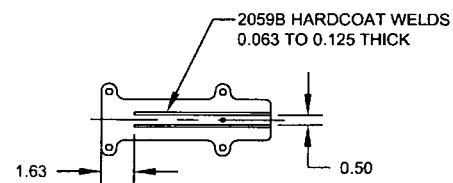
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**D3508-11F FLAT PATTERN****D3508-11 BENDING DETAIL**
(MAKE FROM D3508-11F)**DETAIL A**
(SCALE 2:3)**SECTION B-B**
(SCALE 2:3)**D3508-13F FLAT PATTERN****D3508-13 BENDING DETAIL**
(MAKE FROM D3508-13F)**DETAIL C**
(SCALE 1:2)**D3508-13 WELDING DETAIL**RELEASED
07-11-14

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO.	REV. C
MFG. APPR.	PH	D3508	SHEET 2 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARPLATE	1:6
DATE	07.04.20	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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